

Work Order ID 86158

86158

Page 1

June-21-12 10:04:54 AM

Item ID: D3280-1L08

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Floor Protector, LH

Stop

NS2

Start Date: 21/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/21

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3280	Rev E
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100		0.00
-----	--	------

100

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

x 4

DL

12/06/25

105		0.00
-----	--	------

105

Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240°F

Time IN: 2:00 pm 12/06/24

Time OUT: 7:00 am 12/06/25

x 4

DL

12/06/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 05/07/2012 Req'd Qty: 4.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110	THERMOFORMING MACHINE								
Thermoform	Memo	0.00				x4			Dh 12/06/25
Thermoforming Machine	Thermoform as per Dwg. D3280 and Folio FTA 011								
	Dwg. Rev. <u>E</u>								
	Folio Rev. <u>2</u>								
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00				x4			Dh 12/06/25
Quality Control									
130		0.00							
130	HAND FINISHING THERMOFORMING								
Thermoform	Memo	0.00				x4			Dh 12/06/25
Thermoforming Machine	Trim to Finished Dimensions								

W/O:		WORK ORDER CHANGES					
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Start Date: 21/06/2012 **Start Qty:** 4.00

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Cust Item ID:

Required Date: 05/07/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140 QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

150

OC

Memo

0.00

Quality Control

160

0.00

160

Packaging

Packaging

Memo

0.00

Packaging

12-6-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12/6/28 JF
MF 12-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

June-21-12 10:04:59 AM

Page 1

Work Order ID: 86158

86158

Parent Item: D3280-1L08

D3280-1L08

Parent Item Name: Floor Protector, LH

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev. C Added colour cde to D3280-1 11/03/03 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	993.7469	4.333	18.24421			

MI FXS 118-90318-08

**

Lexan Sheet

Location

Loc Qty

Loc Code

therm

993.7469406

113127

993.746941

18.25 sq ft

Dr.
12/06/20.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 86158
Description: R22 Floor Protector, LH		Part Number: D3280-1
Inspection Dwg: D3280	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <i>Wh</i>	Date: 12/06/25
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	+/-0.100	18.25"	✓		TAPE DL-01	
16.0	+/-0.100	15.9"	✓		TAPE DL-01	
12.1	+/-0.100	12.0"	✓		TAPE DL-01	
0.95	+/-0.030	0.97"	✓		VENN DL-02	
0.25	+/-0.030	0.28"	✓		VENN DL-02	
0.070	Min	0.101"	✓		CAL TH-DT	
0.050	Min	0.070"	✓		CAL TH-DT	

Measured by: <i>Wh</i>	Date: 12/06/26
Audited by: <i>STB</i>	Date: 12/06/26
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	11.04.28	Dwg Rev updated	KJ	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

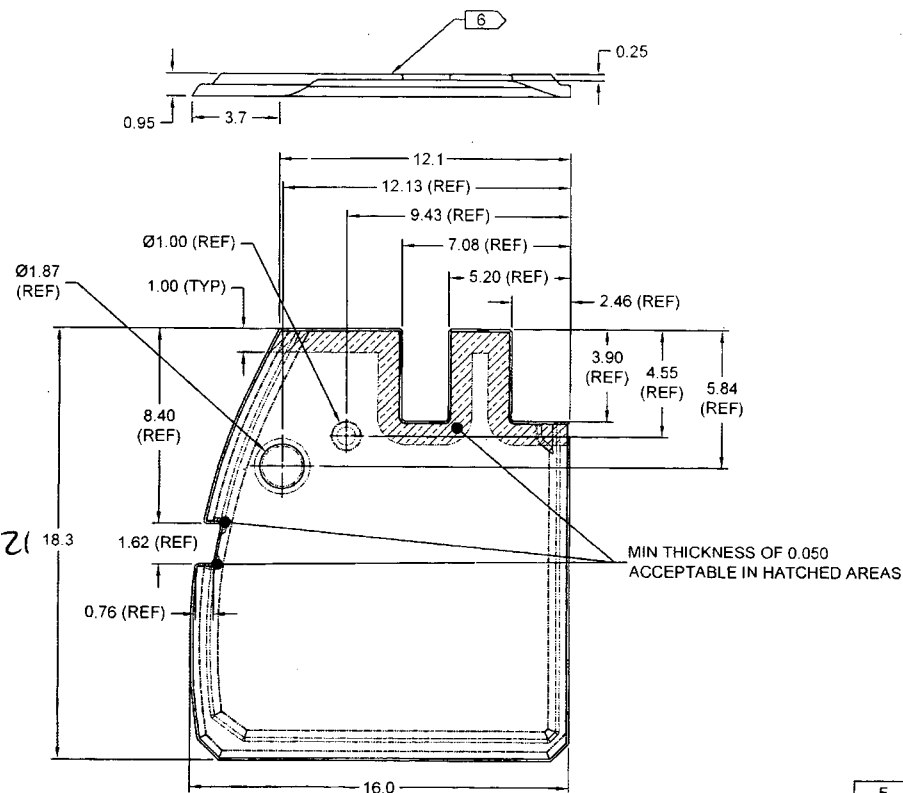
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86158 MLS

12/06/21



D3280-1 FLOOR PROTECTOR

D3280-1 NOTES:

1) MATERIAL: -1L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-1L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-1Lxx" AND B/N PER QSI 044 6.4

7) WEIGHT: D3280-1L02 = 0.94 lb D3280-1L08 = 1.13 lb

8) THERMOFORM WITH MOLD D3280-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED



RELEASED
R 2011-03-02
MP

REV.	DESCRIPTION	BY	DATE
E	REVISE NOTES (ZN A8-1, A8-2)	RF	11.03.01
D	THICKNESS 0.093 WAS 0.125, MIN. THICKNESS 0.070 WAS 0.080, P/N & B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2); CORRECT WEIGHTS (ZN A8-1, A8-2); HOLE SIZE Ø1.88 WAS Ø0.211 (ZN C7-1)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.12
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
DESIGN	40		
DRAWN	RF		
CHECKED	MP		
MFG. APPR.	MP		
APPROVED	MP		
DE APPR.	MP		
DATE	11.03.01		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3280
REV. E
SHEET 1 OF 2
TITLE FLOOR PROTECTOR
SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

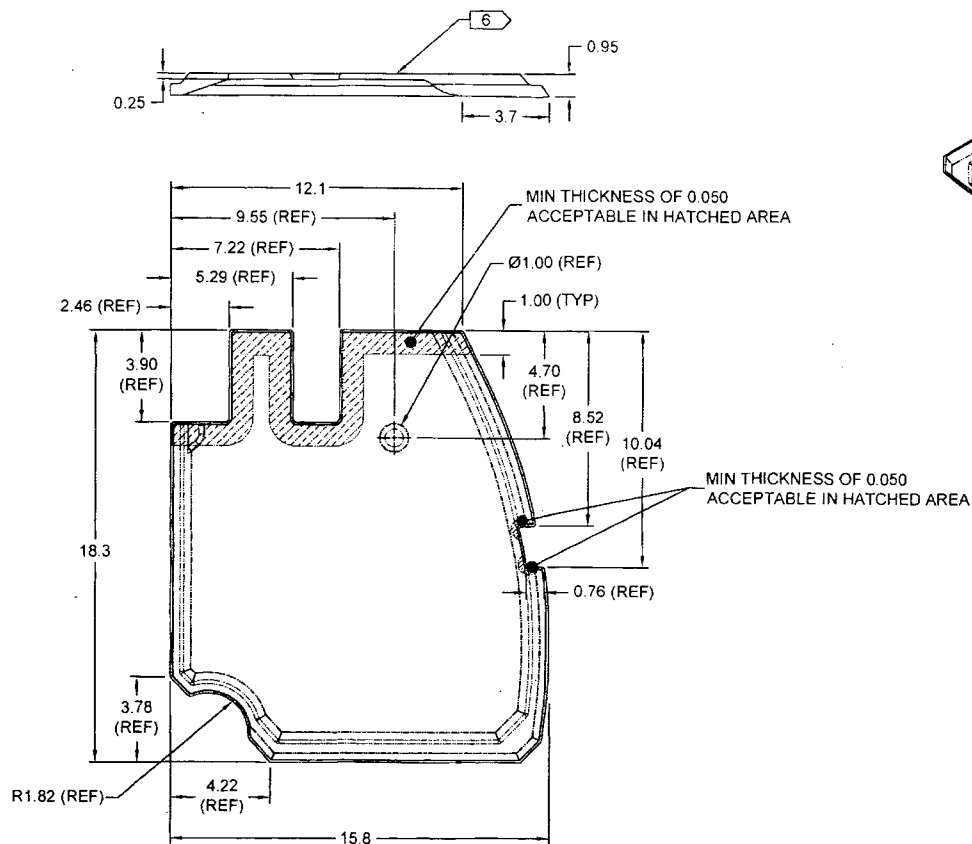
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

86158



D3280-3 FLOOR PROTECTOR

RELEASED
2011-03-03

D3280-3 NOTES:

- 1) MATERIAL: -3L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-3L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-3Lxx" AND B/N PER QSI 044 6.4
- 7) WEIGHT: D3280-3L02 = 0.88 lb D3280-3L08 = 1.03 lb
- 8) THERMOFORM WITH MOLD D3280-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED



DESIGN	97	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	41	DRAWING NO.	REV. E
MFG. APPR.	41	D3280	SHEET 2 OF 2
APPROVED	41	TITLE	SCALE
DE APPR.	41	FLOOR PROTECTOR	NTS
DATE	11.03.01	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS RECOGNITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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